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(54) PRODUCTION OF BRAZING FILLER METAL

(57) Abstract:

PURPOSE: To easily produce brazing filler metal capable of brazing firmly, by mixing Cu, Sn, Fe, Ni, Si, Zn by specified ratio and melting, then solidifying into bar or powder form.

CONSTITUTION: Cu; 65 to 58%, Sn; 2 to 0.5%, Fe; 1.5 to 0.5%, Ni; 1.5 to 0.5%, Si; 1.5 to 0.2%, and Zn; 29 to

41.3% are mixed and melted, then solidified to produce brazing filler metal in bar or powder form. When this brazing filler metal is used for brazing of iron base metal, the action of Si in the brazing metal is restricted by Fe in the same metal, making it difficult to alloy with Fe in the iron base metal to form FeSi, so that a firm junction may be obtained.

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